

Work Order ID 85760

Thursday, June 14, 2012 2:29:47 PM

85760

Page 1

Item ID: D3016-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Seat Frame Assembly

Start Date: 6/14/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/25/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MFDate: 12-06-14 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3016	RevA / DEO A-1								
100	Weld per dwg A/R 4130 rod Batch: <u>M 118875</u>	0.00							
100	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut all tubes as per Dwg D3016								
	2-Deburr								
	3-Assemble tubes, fittings and weld as per Dwg D3016 using welding jig DT8597								
	4-Transfer drill holes from D3017-041 and D3021-041 in seat frame D3016-041								
	5- Assemble brackets and gusset per dwg and weld								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110	QC								
Quality Control	Memo	0.00							

①

EL 12-10-5

1

①

12-10-09DAS
18
8-83

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3016-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Seat Frame Assembly
 Start Date: 6/14/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 6/25/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC5- Inspect part completeness to step on W/O 0.00

120

QC

Memo

Quality Control

130 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00

130

Powdercoat

Powder Coating

Memo

Install paint screws on fitting ends

START TIME: 10:50

OVEN TEMPERATURE: 3200F

FINISH TIME: 11:20

140 QC3- Inspect Part Finish 0.00

140

QC

Memo

Quality Control

12/10/09

1 x 4 20 11/10/09

W122966

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Revision ID:

Item Name: Seat Frame Assembly

Stop ***NS2***

Start Date: 6/14/2012 Start Qty: 1.00

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Cust Item ID:

Required Date: 6/25/2012 Req'd Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>GA</i>	0.00							
150						<i>1x</i>			<i>2/10/11</i>
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									<i>12/10/11</i>
QC	Memo	0.00							
Quality Control									<i>MF</i> <i>12-10-14</i>

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 85760

Parent Item: D3016-041

Parent Item Name: Seat Frame Assembly

Start Date: 6/14/2012

Required Date: 6/25/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A01.09.19New issueECIPP RevB: as per revB. DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.750W.049 4130 RD Tube .750 x.049W		Purchased	No			100	f	105.9200	4.3	4.5263158			
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						MAT033	105.92						
						120350	65.61						
						121025	40.31						
M4130NT0.500W.049 4130 RD Tube .500 x.049W		Purchased	No			100	f	43.4800	4.3	4.5263158			
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						MAT032	43.48						
						121025	43.48						
M4130NT1.000W.120 4130 RD Tube 1.00 x .120wall		Purchased	No			100	f	64.5300	1.5	1.5789474			
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						MAT033	64.53						
						117656	20.27						
						117973	44.26						
D3016-17 Gusset		Manufactured	No			100	Each	22.0000	2	2			
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA021	22						
						70872	12						
						70909	10						
D3016-13 Bracket		Manufactured	No			100	Each	6.0000	2	2			
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA021	6						
						76567	6						

86701 x 0

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 85760

Parent Item: D3016-041

Parent Item Name: Seat Frame Assembly

Start Date: 6/14/2012

Required Date: 6/25/2012

Start Qty: 1.00

Required Qty: 1.00

D3016-15 Manufactured No 100 Each 8.0000 2

Gusset

EL² 12-10-5

86648x2 Location Loc Qty Loc Code

WA 8

77579 8

D3020-1 Manufactured No 100 Each 8.0000 4

Fitting

EL⁴ 12-9-27

Location Loc Qty Loc Code

WA021 8

36713 1

76579 7

85978x4

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

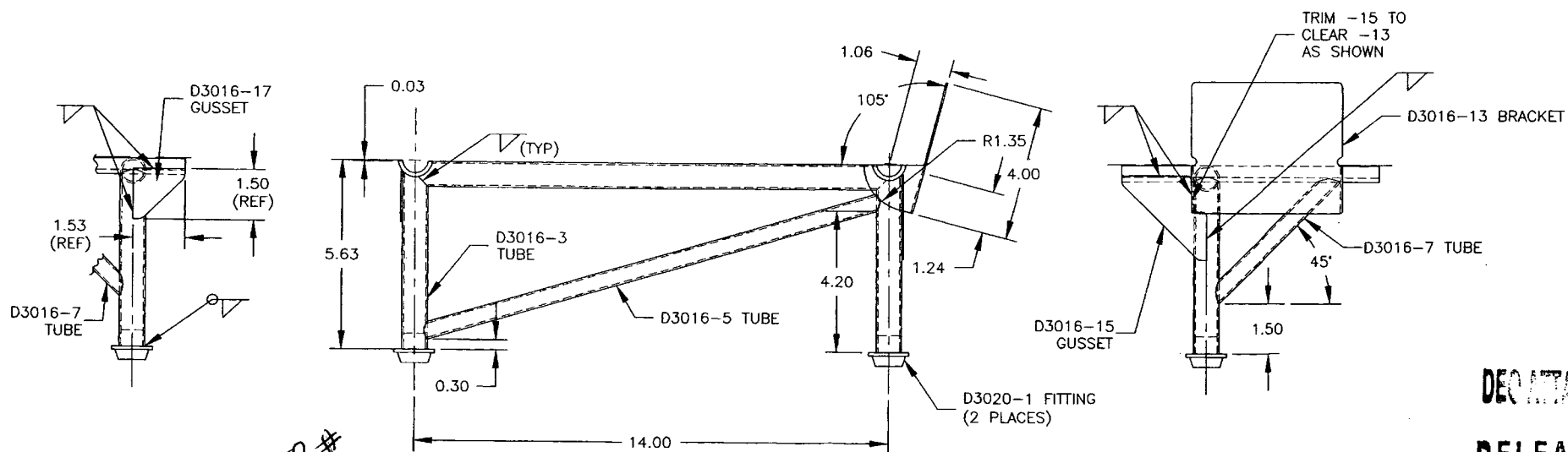
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Diagram illustrating the elevation view of the D3016-1 tube assembly, showing dimensions and components:


- Dimensions:**
 - Overall height: 6.65 (REF)
 - Height from centerline to top saddle: 5.13
 - Height from centerline to bottom saddle: 5.13
 - Height from centerline to top saddle (right side): 3.33 (REF)
 - Height from centerline to bottom saddle (right side): 4.50 (REF)
 - Height from centerline to bottom saddle (right side): 7.63 (REF)
- Components:**
 - D3016-9 SADDLE (Top saddle on the left)
 - D3016-11 SADDLE (Top saddle on the right)
 - D3016-1 TUBE (The central horizontal tube)



09LS8#

DEB ATTACHED

RELEASED
01.05.30

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	CHECKED	APPROVED		DRAWING NO.	REV. A
	DATE			D3016	SHEET 2 OF 3
	01.05.18			TITLE	SCALE
			SEAT FRAME ASSEMBLY	1:3	

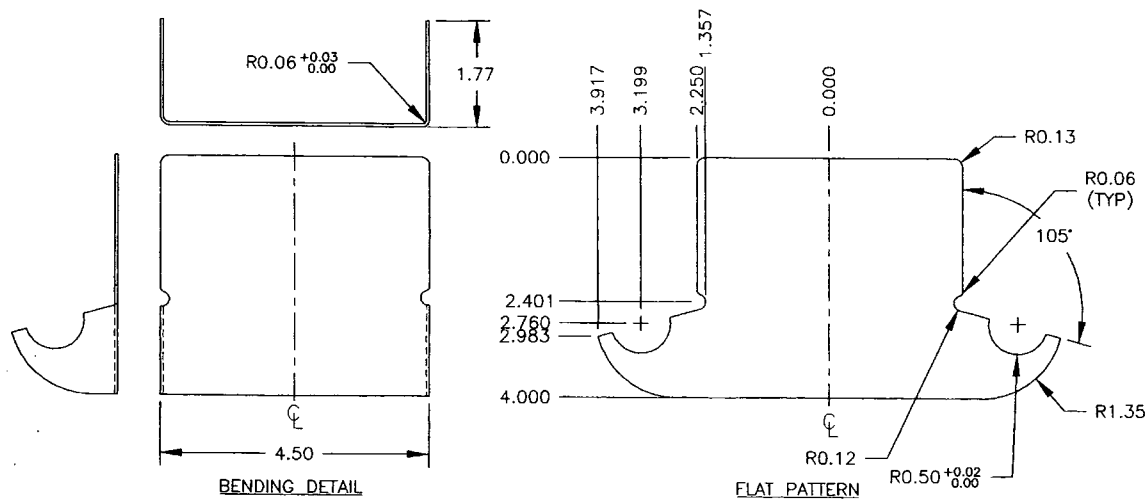
W/O:		WORK ORDER CHANGES					
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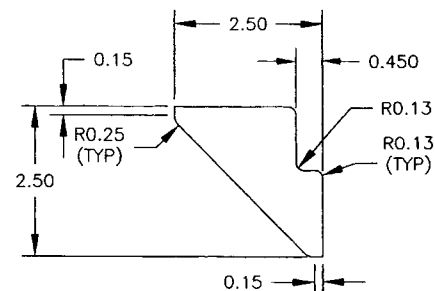
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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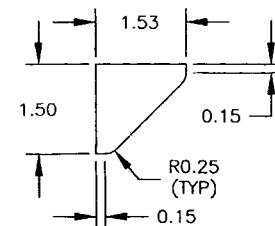
NOTE: Date & initial all entries



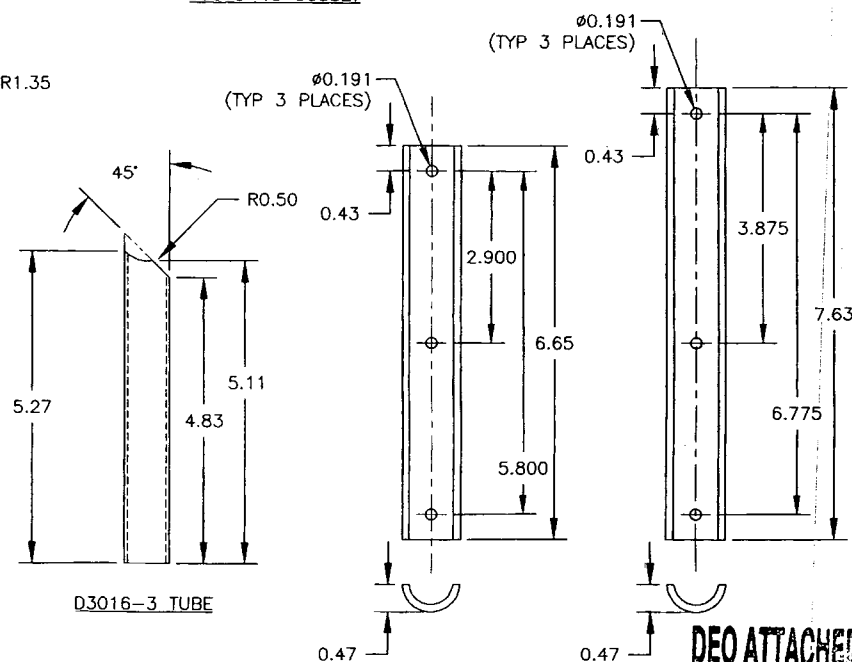
D3016-13 BRACKET



D3016-15 GUSSET



D3016-17 GUSSET



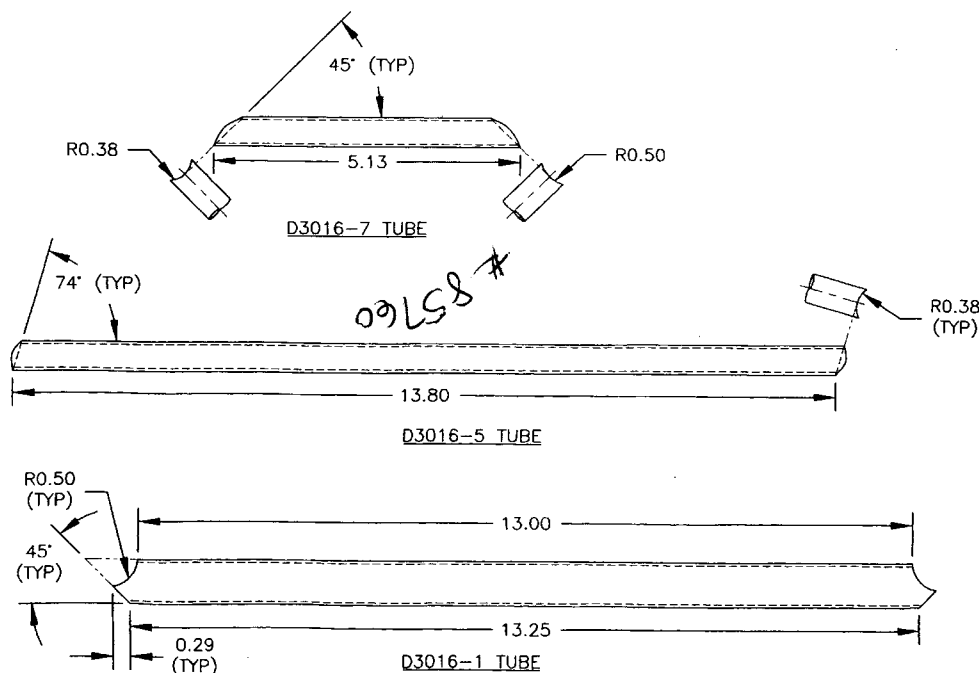
D3016-3 TUBE

D3016-9 SADDLE

D3016-11 SADDLE

DEO ATTACHED
RELEASED
9.05.30

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CHECKED	APPROVED	DRAWING NO.		REV. A	
DATE	DATE	D3016		SHEET 3 OF 3	
01.05.18		TITLE		SCALE	
		SEAT FRAME ASSEMBLY		1:2	



W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DRAWING NO. D3016	TITLE SEAT FRAME ASSEMBLY	REV. A	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3016-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>1</i>	CHECKED <i>UP</i>	MFG. APPR. <i>RE</i>	APPROVED <i>MAP</i>	DE APPR. <i>#</i>		
DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29		

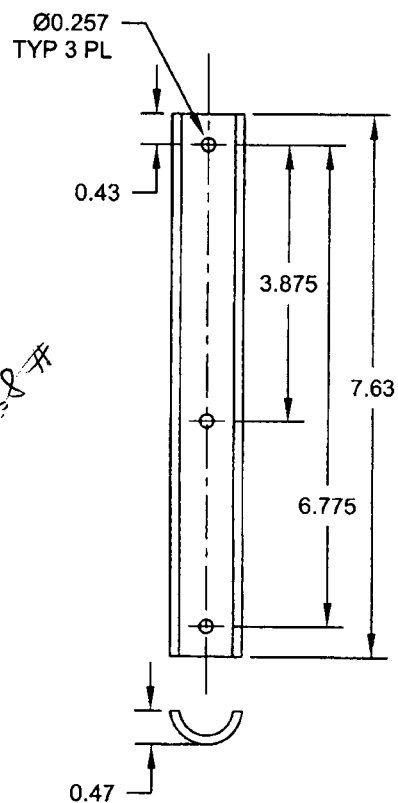
PURPOSE:

TO REVISE D3016-11 SADDLE'S HOLE SIZES

CHANGE:

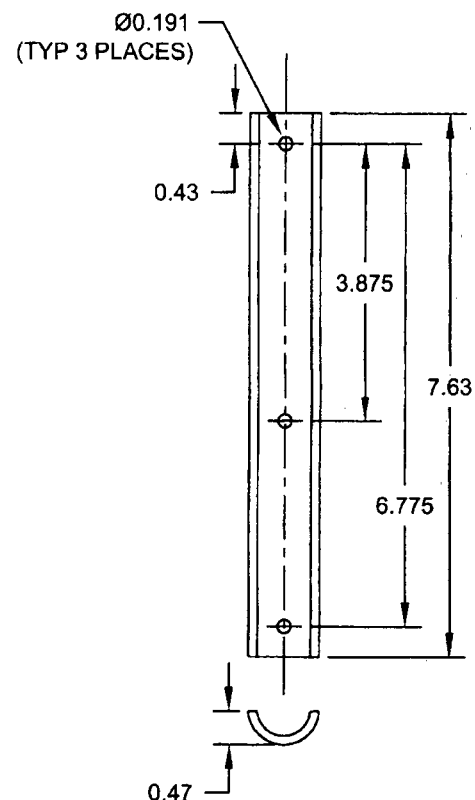
DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

IS:



D3016-11 SADDLE

WAS:



D3016-11 SADDLE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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